

Order ID 55509



Page 1

January 19, 2010 2:25:25 PM

Item ID: D350-748-101

Accept



Setup Start



Revision ID:

Item Name: Crosstube Installation, High Fwd

Stop



Start Date: 1/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 2/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-1-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-748-141	Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-748-101

CHG001

8/10/06/20

HJ for CL 10/18/19

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT

IX 2 MB 12-02-01

120

0.00



QC15- Crosstube Dimensional Check

QC

Memo

0.00

Quality Control

CP 10.06.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Crosstubes	0.00							
	Crosstubes								
Crosstubes	Memo	0.00							
	1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs. Set-up drill table as per QSI 010								
	2-Deburr								
	3-Engrave Part # and Batch # as per Dwg D350-748-141								
	4-Remove all marks from tube within limits of D350-748-141								
	5- Apply a light coat of LPS3 on the interior of tube Batch: _____								
140	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							
	CHECK 10 DEG HOLES WITH DT8876E (EUROCOPTER CLAMP)								

MB 10-06-02

AWM 10-6-04

8/10/02/15

tube were sent to CROPLATIN
with out any holes being inspected

W/O:		WORK ORDER CHANGES					
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January 19, 2010 2:25:25 PM



Page 3

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Outsource process-Cadplate per QSI017 4.1.9.1	0.00							
Outsource3	Memo	0.00							
Outsource process - Cad plate	Issue P/O: <u>12043</u> Stress relief at 375° for 5 hours Magnetic Particle Inspect per ASTM E1444 Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2 Embrittle relief at 375° for 8 hours, Chromate Treat Possibe Supplier: Southwest United Industries Ensure Certificate of Conformity is attached								<u>CL 10/6/8</u> <u>①</u>
160 	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								<u>CL 10/8/09</u> <u>①</u>
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									<u>8 10/02/17</u> <u>70</u>

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January 19, 2010 2:25:25 PM



Page 4

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

180

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside crosstube as per QSI 005 4.2
2-Prime Outside of Tube as per Dart QSI 005 4.2

RT 10-08-18 (X1)

190

0.00



QC14- Inspect Spray Paint

QC

Memo

0.00

Quality Control

Then, Wrap in plastic bag to protect from scratches

ML 10-08-19 (1)

200

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Install Ground wire Insert, then insert screw and washer
2-Install Abraison strips as per Dwg D350-748-141 & QSI 035.
3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

RT 10-08-19 (X1)

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January 19, 2010 2:25:25 PM



Page 5

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/08/19



Quality Control

220

Pick Kit

0.00



Packaging

Memo

0.00

10/8/20 sf

Packaging

230

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

8/10/08/20

Quality Control

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January 19, 2010 2:25:25 PM



Page 6

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-748-101

Location: _____

PPP Rev: B

10/01/2010

250

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/08/23

mmf

10-8-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

January 19, 2010 2:25:24 PM

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Comments: IPP Rev:A New Issue 06-07-05 JLM
 IPP Rev:B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev:C Rev B 07-11-15 DD
 IPP Rev D Combined manufacturing ^08.04.02 EC verified by: DD

Start Date: 1/20/2010

Required Date: 2/9/2010

Start Qty: 1.00

Required Qty: 1.00

D350-748-141TRN

Manufactured No

110

Each

5.0000

1.0000



Crosstube Turning Detail

B-55301 MB 10-05-31

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

5

37995

1

37999

1

40099

1

40103

1

50622

1

ALS4-1032-225

Purchased

No

200

Each

6,686.000

1.0000



Insert

W115107

RT 10-08-19

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6686

107441

16

110768

6670

AN960JD10

Purchased

No

200

Each

0.0000

1.0000



Washer

W115107

RT 10-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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January 19, 2010 2:25:24 PM

Page 2

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 IPP Rev:B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev:C Rev B 07-11-15 DD
 IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D2856-400

Manufactured No

200

f

290.3921

1.2432



Abraison Strip

B56626 v1-2432



ST 10-10-19

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

290.3920842

50593

141.312084

52563

149.08

D3500-1

Manufactured No

200

Each

46.0000

4.0000



Saddle

220



B55605 10/8/2008

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46

47119

12

47350

5

52326

20

53792

9

January 19, 2010 2:25:24 PM

Shop Packet Print

Page 2

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January 19, 2010 2:25:24 PM

Page 3

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IPP Rev:B Update qty of MS21042L5 06-09-12 KJ
IPP Rev:C Rev B 07-11-15 DD
IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D3502-1

Manufactured No

200

Each

83.0000

2.0000



Support

Handwritten signature/initials



Handwritten: ST 10-08-19

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

41603

2

42968

2

47120

1

Handwritten: X1

Main Warehouse

ST107

40

52903

40

Handwritten: X1

Main Warehouse

ST168

38

50287

38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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January 19, 2010 2:25:24 PM

Page 4

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IPP Rev:C Rev B 07-11-15 DD
IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

MS21920-20

Purchased

No

200

Each

115.3000 2.0000



Clamp (per MIL-DTL-8783C)

M 114687 x2



ST 10.08-19

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

115.3

103478

2

106484

12

109269

9.3

110536

10

112307

32

112624

39

112793

11

MS27039-1-10

Purchased

No

200

Each

203.0000 1.0000



Screw



ST 10-08-19

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

203

112794

89

112828

14

112940

100

January 19, 2010 2:25:24 PM

Shop Packet Print

Page 4

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January 19, 2010 2:25:24 PM

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IPP Rev:C Rev B 07-11-15 DD
IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

AN4-41A

Purchased

No

220

Each

242.0000

8.0000



Bolt



10/8/2009

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

242

105940

4

110363

16

110731

50

111424

50

112082

22

113359

100

AN4-6A

Purchased

No

220

Each

1,559.000

16.0000



Bolt



10/8/2009

10/8/2009

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1559

112314

159

112641

100

112720

100

112829

300

112933

300

113149

600

10/8/2009

10/8/2009

10/8/2009

January 19, 2010 2:25:24 PM

Shop Packet Print

Page 5

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IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD

Start Date: 1/20/2010

Required Date: 2/9/2010

Start Qty: 1.00

Required Qty: 1.00

AN5-32A Purchased No 220 Each 175.0000 4.0000
Bolt

M15072 10/18/2009

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	175
106242	3
106519	4
110363	17
112805	1
112933	50
113121	100

AN960JD416 Purchased No 220 Each 149.0000 32.0000
Washer

M115000 10/18/2009

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	149
112314	149
16941	0

AN960JD516 Purchased No 220 Each 0.0000 8.0000
Washer

M114742 10/18/2009

January 19, 2010 2:25:24 PM

Shop Packet Print

Page 6

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Page 7

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 IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D3501-1

Manufactured No

220

Each

523.0000

16.0000



Bushing



10/8/2008

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

523

45402

19

45918

200

~~48268~~

204

53779

100

10

MS21042L4

Purchased No

220

Each

3,697.000

24.0000



Nut



MIN784 10/8/2008

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3697

102552

6

104248

6

110507

184

111827

2501

113422

1000

15924

0

January 19, 2010 2:25:24 PM

Shop Packet Print

Page 7

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Page 8

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IPP Rev:C Rev B 07-11-15 DD
IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

220

Each

550.0000 4.0000



Nut



M114813 10/8/2008

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

550

110382

10

111636

1

112314

39

113523

300

113537

200

January 19, 2010 2:25:24 PM

Shop Packet Print

Page 8

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

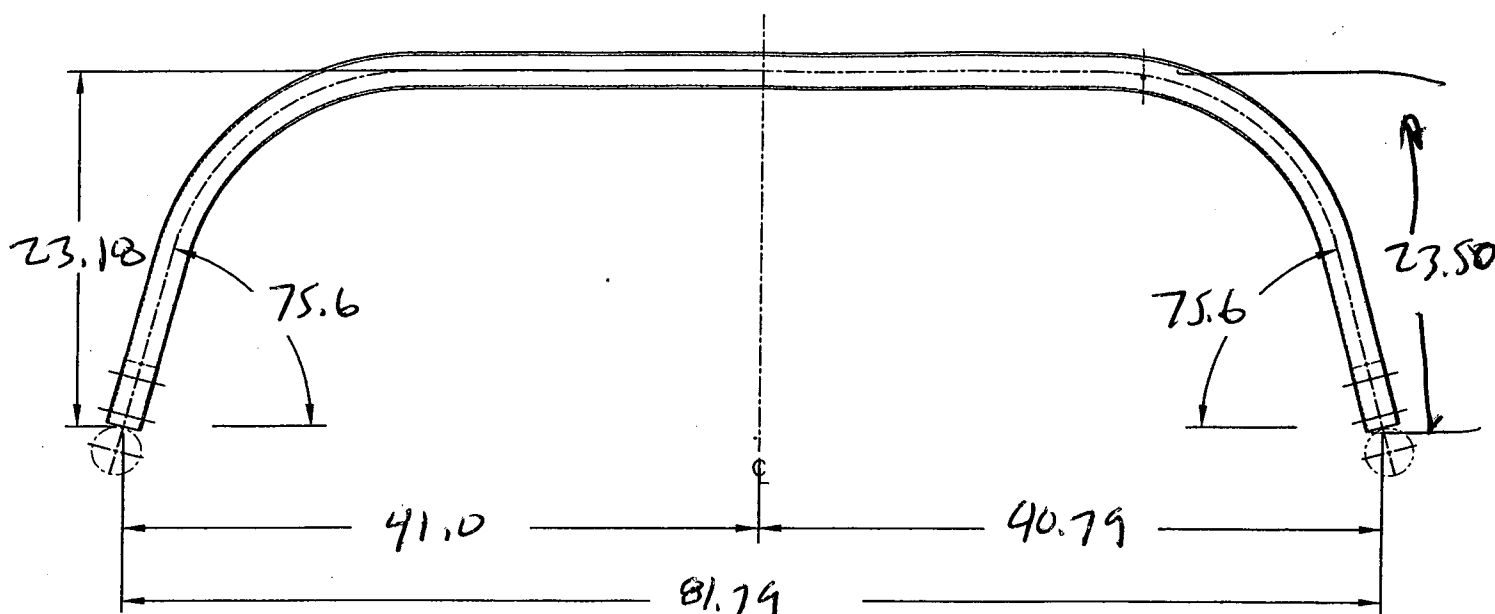
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55509
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141	Rev: D E	Page 1 of 1	

10.01.19

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
Cut 23.50 by approx 0.188"
Twist = 0.258

QC15 Inspection	P 10.06.07
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty	Part Number	Description
	-141		
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6017-115	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6017-115
FINISHED LENGTH = 110.270±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

#55509

RELEASED
R 2009-10-29
JWP

E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D350-748-141	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

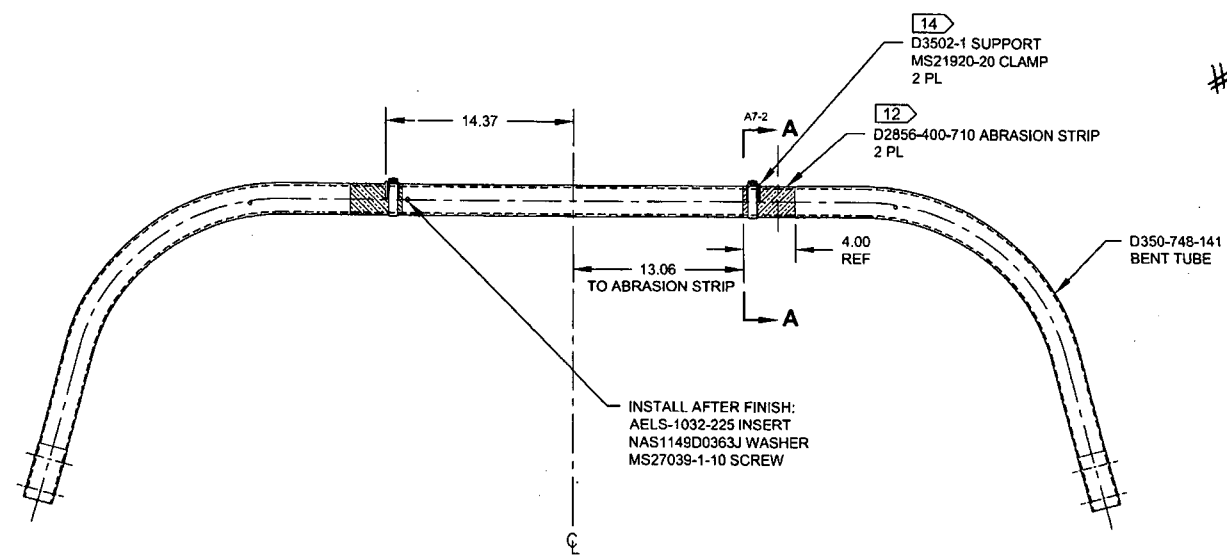
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

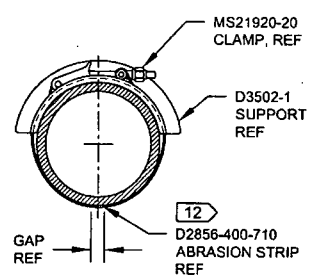
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

55509



**D350-748-141
ASSEMBLY DETAIL**



SECTION A-A D4-2
SCALE 4X

RELEASED
2009-10-29

DESIGN	97	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. E
MFG. APPR.	18	D350-748-141	SHEET 2 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	11	CROSSTUBE (AS 350/355 HI FWD)	NTS
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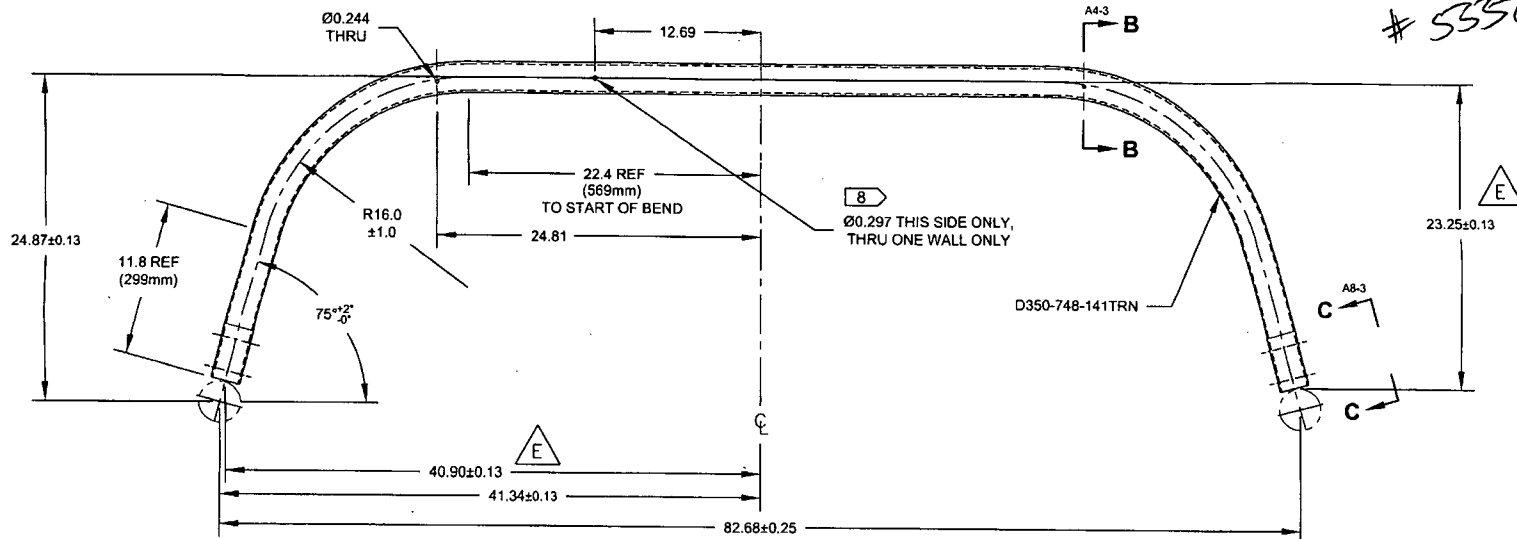
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

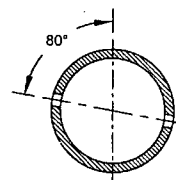
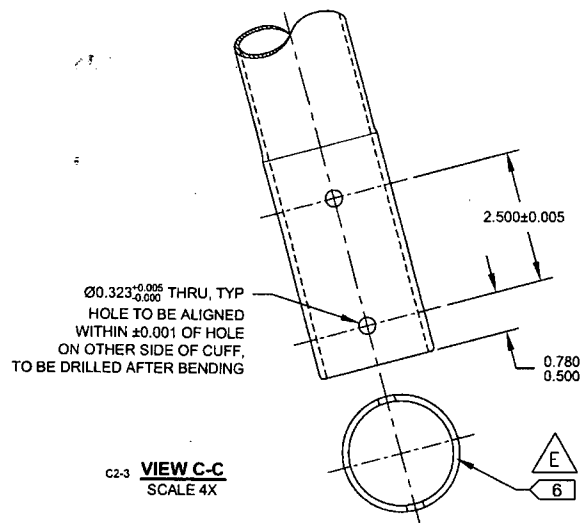
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-748-141
BENDING AND DRILLING DETAIL



SECTION B-B D3-3
 SCALE 4X

RELEASED
 2009-10-29

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D350-748-141	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE (AS 350/355 HI FWD)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

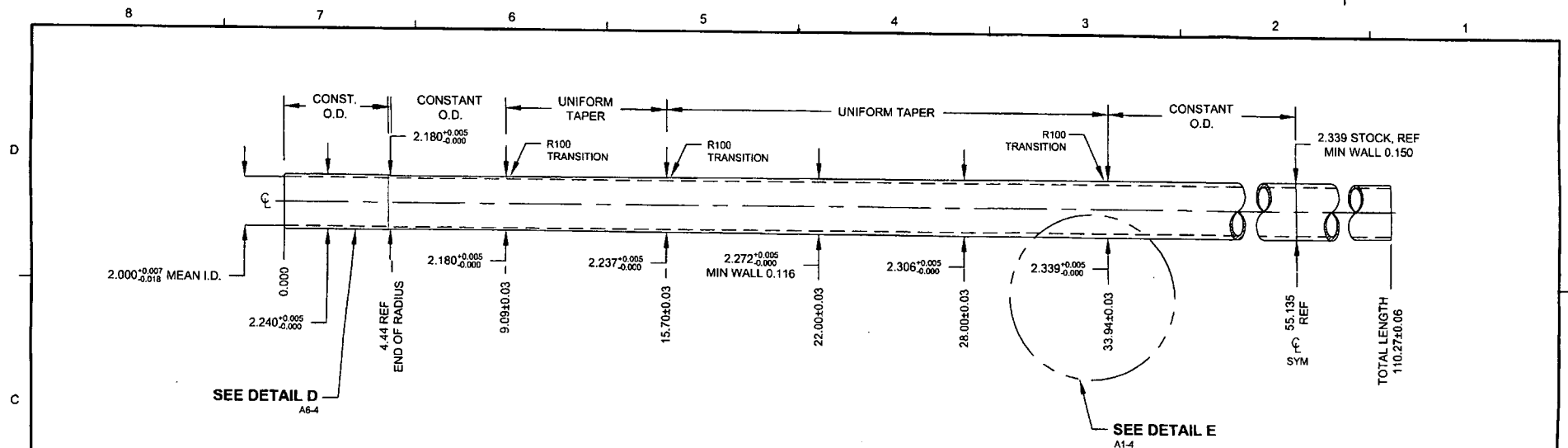
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

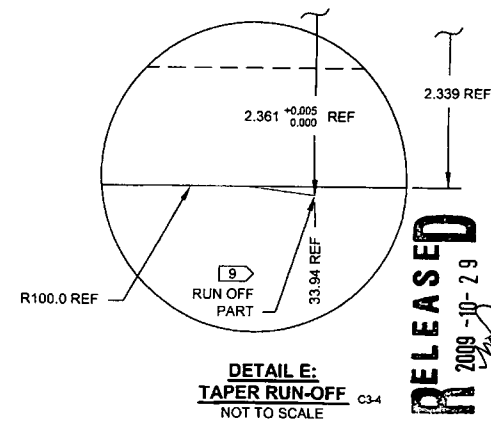
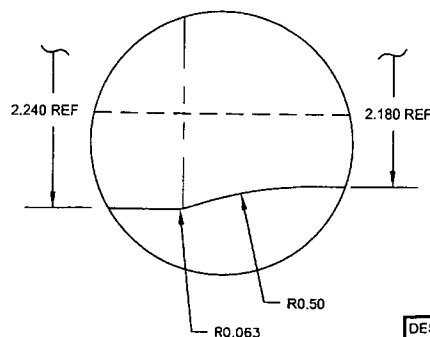
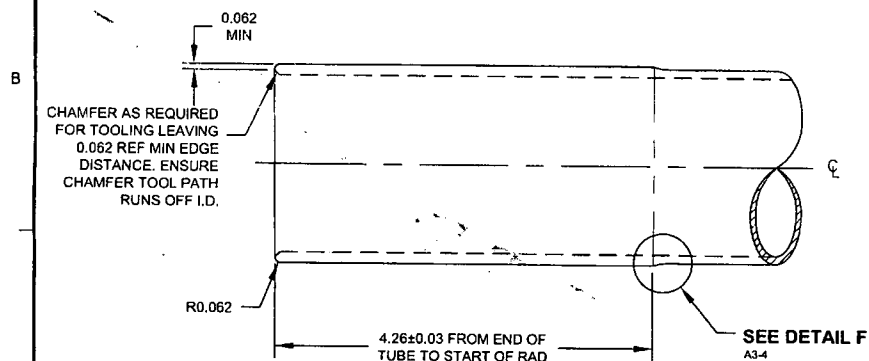
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#53509



**D350-748-141TRN
TURNING DETAIL**



DESIGN	40	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	40	DRAWING NO.	REV. E
MFG. APPR.	40	D350-748-141	SHEET 4 OF 4
APPROVED	40	TITLE	SCALE
DE APPR.	40	CROSSTUBE (AS 350/355 HI FWD)	NTS
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2009-10-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Jul-05-2010

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 96455
INVOICE #: 50228

**CONTRACT OR
PURCHASE ORDER #**

12043

DESCRIPTION: SKID

QTY

1

P/N # d350-748-101

S/N # B55509

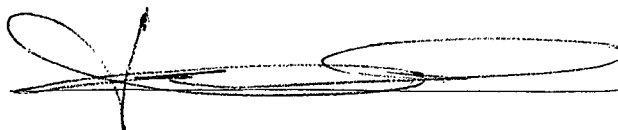
**STRESS RELIEF HEAT CHART #10-639. MPI IAW ASTM-E-1444.
CADMIUM PLATE IAW AMS-QQ-P-416B TYPE 2 YELLOW CLASS 1.
BAKE HEAT CHART # 10-686.**

Sidlokin

*tube Damage Dunn's transport
see next Page.*

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:



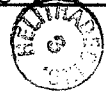
W/O: .		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 350-748-101 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 4 Date: 1008-18

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>SS509</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.08.18	150	DAMAGE TO CAD PLATE DUE TO TRANSPORT ACCIDENT REF. NCR 10-308	<u>CP</u> 10.08.18 QS1042	Touch up CAD PLATE PER QSA 1CA-D350-748 CHAPTER 5	<u>see</u> <u>next</u> <u>page</u>	<u>S</u> 10/08/18	<u>CP</u> 10.09.18 QS1042	<u>1008-18</u>

NOTE: Date & initial all entries

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form tracking No. HTV-2635 Page 1 of 1	
4. Approved organization name and address HELITRADES INC. 18 Terry Fox Drive, Vankleek Hill, Ontario, K0B 1R0, Canada					5. Work order/contract/invoice H-16610	
6. Item	7. Description	8. Part No.	9. Qty	10. Serial/Batch No.	11. Status/work	
1	CROSSTUBE	<u>D350-748-101</u>	2	<u>55509</u> 55511	REPAIRED <i>10/03/09</i>	
12. Remarks BRUSH CADMIUM PLATING REPAIR CARRIED OUT I.A.W. THE DART AEROSPACE ICA-D350-748 PAGE 9 OF 19 REV.1. DOCUMENTATION FOR ALL WORK PERFORMED IS AVAILABLE ON FILE UNDER HELITRADES W/O SPECIFIED IN BLOCK # 5.						
13a. Certifies that the items identified above were manufactured in conformity to: <input type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input checked="" type="checkbox"/> CAR 571.10 Maintenance Release. <input type="checkbox"/> Other regulations specified in block 12. Certifies that, except where otherwise specified in block 12, the work identified in block 11 and described in block 12 was performed in accordance with the Canadian Aviation Regulations.			
13b. Signature		13c. Approved Organization Number		14b. Signature <i>[Signature]</i> 		14c. Approved Organization Number AMO 3/86
13d. Name		13e. Date (dd/mm/yyyy)		14d. Name GERALD TOM		14e. Date (dd/mm/yyyy) 17-Aug-10
<p>"This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown."</p>						

(Previously form 24-0078)

5.0 PARTS LIST

Qty -101	Qty -201	Part Number	Description
X		D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1		D350-748-141	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD
	1	D350-748-241	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT
*2	*2	D3502-1	SUPPORT
*2	*2	D2856-400-710	ABRASION STRIP
*1	*1	AELS-1032-225	INSERT
*2	*2	MS21920-20	CLAMP
*1	*1	MS27039-1-10	SCREW
*1	*1	AN960JD10	WASHER
4	4	D3500-1	SADDLE
16	16	D3501-1	BUSHING
16	16	AN4-6A	BOLT
8	8	AN4-41A	BOLT
4	4	AN5-32A	BOLT
32	32	AN960JD416	WASHER
8	8	AN960JD516	WASHER
24	24	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

* REFERENCE ONLY. PARTS ARE INCLUDED IN D350-748-141/241 ASSEMBLIES ABOVE

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Revision: B

Date: 07.06.15